



Dart Aerospace Ltd.
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RBT18560
Job Sheet 198886



Part No: RBT18560

Job Qty: 1 pcs *3 HLL*

Part Name: Engine Gearbox Seal Puller



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/7/19

Job Tracking No:

Due Date: 10/3/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBT18560 Rev 4 IPP Rev A 17.11.07 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	1 pcs	10/3/19		0.00	1.00	Small Fab - 1		<i>HLL</i>
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
120	QC 5	1 pcs	10/3/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 3 - 1 - Stock - B4B	1 pcs	10/3/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		



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Container No: S211749



Part: RBT18560

Job No: 198886

Serial No/Batch: S211749

Revision: 4

Inspector:

Exp Date:

Instructions:

Date: 09/06/19

SEP 05 2019
40
40

				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - FG	1 pcs	10/3/19	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70
					QC 21 - SA - 53

Part Op 110 - (Small Fab) - Assemble as per DWG. Sheet 1
 Descriptions: 120 - (QC5- Inspect part completeness to step on W/O)
 130 - (Identify as per dwg & Stock Location: _____)
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
203 3408A94	Ball Plunger without thread locker	6 2 Ea (2 ea)	110-Small Fab - 1	5133293
65 90565A330	Tall Nut 1/2-20 UNF	3 1 Ea (1 ea)	110-Small Fab - 1	5031237
203 91255A542	Button Head Socket Cap Screw 5/16-20 UNC x 1	6 2 Ea (2 ea)	110-Small Fab - 1	5032752
58 94846A525	Jam Nut 1/2-20	3 1 Ea (1 ea)	110-Small Fab - 1	503248
34 NTA-815	Thrust Bearing	3 1 Ea (1 ea)	110-Small Fab - 1	5133797
RBT18560-1	Puller	3 1 pcs (1 ea)	110-Small Fab - 1	5148267
RBT18560-11	Upright	6 2 pcs (2 ea)	110-Small Fab - 1	5150223
RBT18560-3	Ring	3 1 pcs (1 ea)	110-Small Fab - 1	5146814
RBT18560-5	Screw	3 1 pcs (1 ea)	110-Small Fab - 1	5148382
RBT18560-9	Cross Bar	3 1 pcs (1 ea)	110-Small Fab - 1	5151610
36 TRA-815	Bearing Washer	6 2 Ea (2 ea)	110-Small Fab - 1	5133205

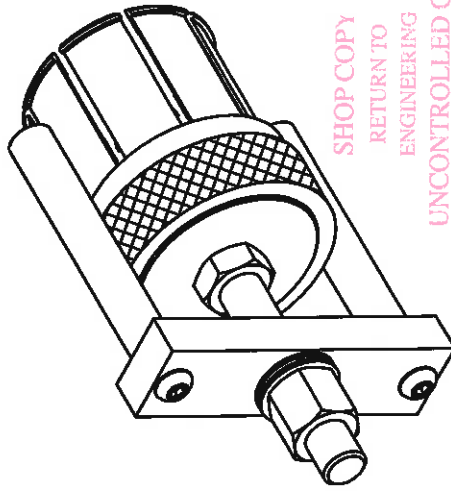
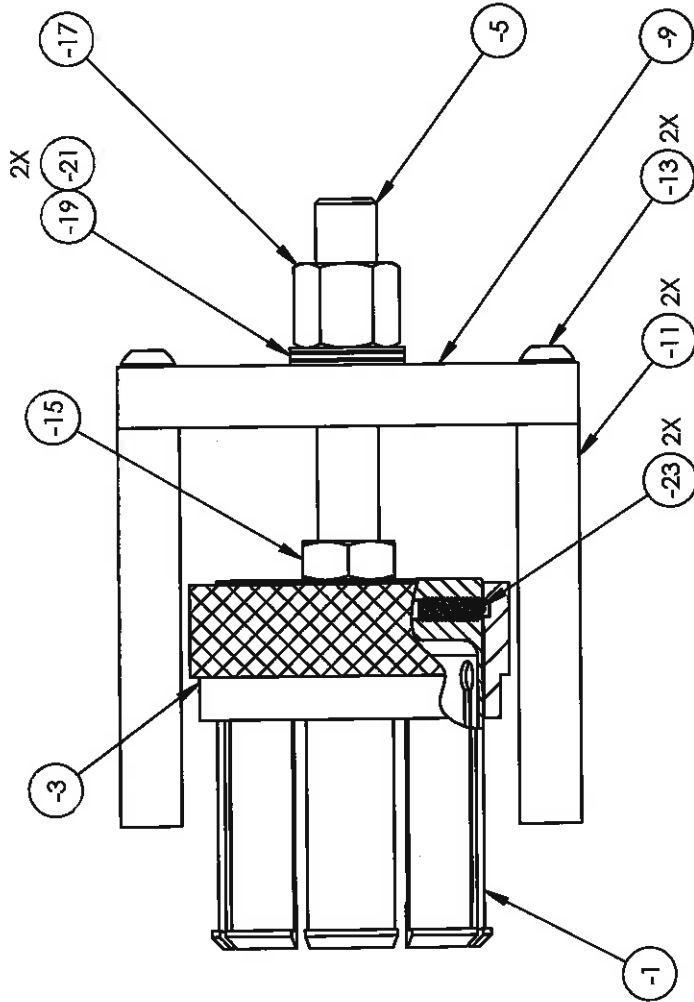
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	3408A94	2	17	0
	90565A330	1	51	0
	91255A542	2	68	0
	94846A525	1	85	0
	NTA-815	1	12	0
	RBT18560-1	1	7	0
	RBT18560-11	2	10	0
	RBT18560-3	1	6	0
	RBT18560-5	1	11	0
	RBT18560-9	1	19	0
	TRA-815	2	30	0
Part Specifications				
Specifications could not be found.				

Plex 8/7/19 9:21 AM Dart.lajeunesse.marie

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TEO ATTACHED

REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		1. PULLER SLOT HOLES INCREASED TO Ø1/4" & WALL THINNED FOR FLEXIBILITY. -3 RING SHORTENED & GROoved TO ALLOW -1 PULLER TEETH TO FULLY EXPAND. -7 ILLUMINATED. -9 CROSS BAR WIDTH INCREASED TO 1 FOR ADDED STRENGTH.	2/12/2003		
2		ADDED NEW BOM, TITLE BLOCK, & REV. TABLE. RE-ORGANIZED DWG.'S AND CORRECTED ERRORS. CREATED AN ASSEMBLY DWG. AND COMBINED TWO FILES.	11/20/2007	WP	RW
3		CHD -9 HOLE FROM Ø.250 (X2) TO Ø.257 (X2) SER S.E.	12/29/2011	RJC	SE
4	15-0472	-9 CHD ENGRAVE NOTE TO T/N, S/N. "MADE IN USA". UPDATED TO NEW DRAFTING STANDARDS.	1/5/2016	SM	JAG



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WITHOUT NOTICE
WORK ORDER
NO. 198886 405

NOTE:
1. USED ON BELL MODELS 206A, B, L1-L4.
SEAL #406-340-104-101

DART
AEROSPACE

TITLE ENGINE/GEARBOX SEAL PULLER

DWG NO.	RBT18560	REV	4
MAT'L	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES FRACTIONS ± 1/8 DECIMALS ± .005 ANGLES ± .1° SURFACES ± .125/		
FINISH	1. BREAK ALL SHARP EDGES 2. DIMENSIONAL LIMITS APPLY 3. AFTER PLATING AND TOL PER ASME Y14.5-2009		
SPEC			
DRAWN BY:	COLE		
CHECKED:	DUERFELDT		
QTPS APPR:	ANDERSON		
QA APPR:	LINDSAY		
APPROVED:	GILBERT		
SCALE	2:3	DATE	5/2/2002
			SHEET 1 OF 6

ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
		-1	1	PULLER	H13		2
		-3	1	RING	DOM		3
	B/O	-5	1	SCREW	STEEL	1/2-20 UNF X 4 IN THREADED ROD (MCMASTER-CARR # 98750A483) MODIFIED	4
		-9	1	CROSS BAR	1018/1020 CR		5
		-11	2	UPRIGHT	1018/1020 CR		6
	B/O	-13	2	BTH-HEAD SKT CAP SCR	STEEL	1/4-20 UNC X 1 (MCMASTER-CARR # 91255A542)	1
	B/O	-15	1	JAM NUT	STEEL	1/2-20 JAM NUT (MCMASTER-CARR # 94846A525)	1
	B/O	-17	1	TALL NUT	STEEL	1/2-20 UNF (MCMASTER-CARR # 90565A330)	1
	B/O	-19	1	THRUST BEARING	STEEL	APPLIED # NTA-815	1
	B/O	-21	2	BEARING WASHER	STEEL	APPLIED # TRA-815	1
	B/O	-23	2	BALL PLUNGER	S.S.	10-32 X 33/64 (MCMASTER-CARR # 3408A94)	1



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

DISPOSITION		DEPARTMENT/PROCESS			
Job: _____	Rework ☐	Cross tube ☐	Eng. (Non-AW) ☐	Engineering ☐	
Part No. _____	Scrap ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Water Jet ☐	
	Use-as-is ☐	Finishing ☐	Rec/Store/Packaging ☐	Supplier ☐	
		Skid-tube ☐		Quality ☐	
		Machining ☐			
		Large Fab ☐			
Date: _____	Sequence #: _____	QTY Affected: _____			
Description Work Order Deviation		Disposition			
		Completed By			
		Lead hand / Supervisor			
		QC / QA Coordinator			
		MRB (QS1042)			
Root Cause		FAULT CATEGORY			
Operator ☐	Pressure/Forced ☐	Contamination ☐	Power Loss/Surge ☐	Positioned Wrong ☐	
Manufacturing Process ☐	Bending ☐	Misaligned/off center ☐	Folio/Program ☐	Outside Tolerance ☐	
Equip/Tooling ☐	Crushing ☐	BOM/Route ☐	Grain Direction ☐	Drawing ☐	
Handling/Preservation ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Finish ☐	
Material ☐	Crimp/Kink/Ripple/Wave/Twist ☐	Incomplete/Unclear Instructions ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	
Product Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Out of Sequence ☐	Misread ☐	
Process Improvement ☐	Mislabeled ☐	Fit/Function ☐	Off-set/Set-up ☐		
Human Factors ☐	Other/Details: _____				